WORK INSTRUCTION

Title: **Replacement of Threaded Inserts/Fasteners**

Instruction No. CH.06 Rev. 0.3, February 2006

Approved for Use by: Michael R. Brown Effective Date: February 2006

Applicable Drawings:
- 2077-500SNP (Sheets 1-11) - TRUPACT-II Packaging SARP Drawings
- 707-SAR (Sheets 1-12) - HalfPACT Packaging SARP Drawings

SARP Requirements:
- Chapter 8.0, Para. 8.2.3.1. Threaded fasteners are to be inspected before each use and annually for stripped or deformed threads. Damaged components shall be repaired or replaced prior to further use.

Tools Required:
- Stainless steel tube brush 3/8-in. and 5/8-in. diameter
- Calibrated torque wrench with 9/16 hex socket
- 9/32-in. diameter drill bit with collar
- 17/32-in. diameter drill bit with collar
- Appropriately sized short shank "E-Z Out" Tool (depending upon the drill diameter used)
- 1/4-in. diameter punch
- Power drill
- Keensert Installation Tools (PN TD-420L or PN TD-813L)
- 5/8-11 tap
- 3/8-16 tap

Spare Parts Required:
- Fork Lift Pocket Cover, Threaded Insert . . . . . (PN 2077-160-29)
- Outer Containment Vessel (OCV) or Inner Containment Vessel (ICV) Lock Bolt, Threaded Insert . . . . . (PN 2077-160-28)
- ICV Lock Bolt . . . . . (PN 2077-156-A1)
- OCA Lock Bolt (HalfPACT) . . . . . (PN 2077-156-A1)
- OCA Lock Bolt (TRUPACT-II) . . . . . (PN 2077-156-A1 or PN 2077-156-A2)

Materials Required:
- Denatured alcohol or equivalent
- Lint-free rags
- Nickel anti-seize thread compound

Safety Requirements:
- Safety will be observed in accordance with site requirements.

Prerequisite Conditions:
- To replace the lock bolt inserts, the ICV lid or OCA lid must be removed.
- There is no requirement to replace components in sequence listed.

Instruction Steps:

- The spare parts listed below shall be replaced with like-for-like components from the approved spare parts supply.
- The replacement of these parts shall be documented on a **Maintenance Record.**
- This instruction **is not required to be attached** to the Maintenance Record but may be used as a checklist during performance of maintenance.

☐ OCA/ICV lock bolt threaded insert . . . . . (PN 2077-160-28) PO#_____

1.0 Obtain power drill and install 17/32-in. diameter drill bit.
2.0 Install drill bit collar on drill bit and set to 3/16-in. maximum drill depth. (If needed, chase threads using a 5/8-11 tap after removal of insert.)
3.0 Follow steps outlined in Attachment 1 for insert removal and installation.

☐ ICV lock bolts . . . . . (PN 2077-156-A1) PO#_____
☐ OCA lock bolts (HalfPACT) . . . . . (PN 2077-156-A1) PO#_____
☐ OCA lock bolts (TRUPACT-II) . . . . . (PN 2077-156-A1) PO#_____
. . . . . or (PN 2077-156-A2) PO#_____

1.0 Clean threads of the insert using 1/2-in. tube brush. Wipe clean using alcohol and lint-free rags.
2.0 Clean threads of replacement bolt using alcohol and lint-free rags.
3.0 Lightly coat bolt threads with nickel bearing lubricant thread compound.
4.0 Install bolt and torque to 28 to 32 lb-ft.

☐ Fork lift pocket cover threaded insert . . . . . (PN 2077-160-29) PO#_____

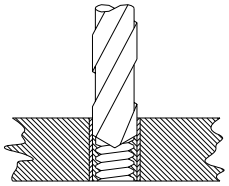
1.0 Obtain power drill and install 9/32-in. diameter drill bit.
2.0 Install drill collar on drill bit and set to 3/16-in. maximum drill depth. (If needed, chase threads using a 3/8-16 tap after removal of insert.)
3.0 Follow steps outlined in Attachment 1.

Verification Requirements:

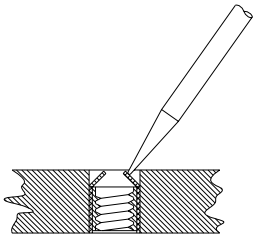
1.0 Spare parts used are listed on the Maintenance Record.
2.0 Work performed is described on the Maintenance Record.
3.0 Work instruction is listed on the Maintenance Record.

ATTACHMENT 1

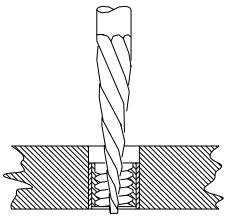
1. USE STANDARD DRILL TO REMOVE INSERT MATERIAL BETWEEN "KEES"



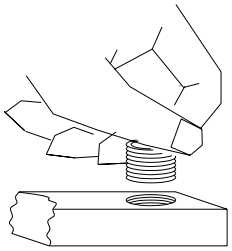
2. DEFLECT "KEES" INWARD AND BREAK OFF.



3. REMOVE INSERT WITH E-Z OUT TYPE TOOL.

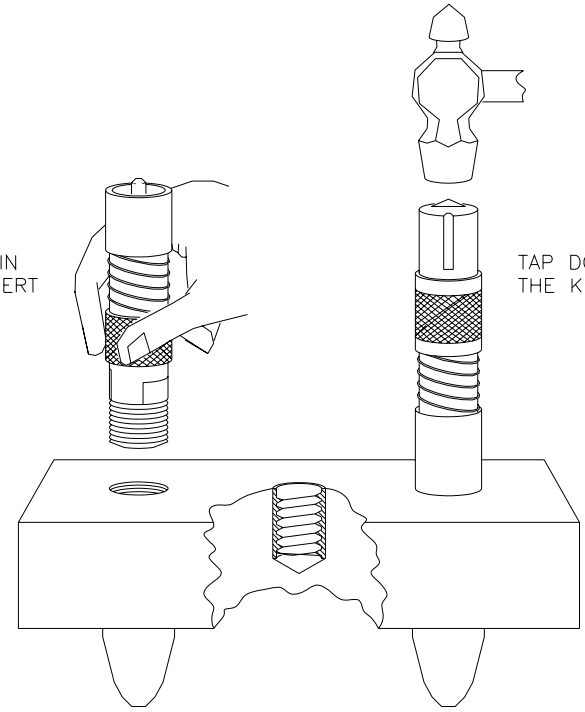


4. AN IDENTICAL INSERT CAN NOW BE INSTALLED IN THE ORIGINAL HOLE. NO RE-WORK OF THE HOLE WILL BE NECESSARY.



SCREW IN THE INSERT

TAP DOWN THE KEES



SCREW IN INSERT WITH FINGERS OR INSTALLATION TOOL. INSERT IS DESIGNED TO STOP AT THE CORRECT DEPTH BELOW THE SURFACE OF THE CASTING.